



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101576-P
Job Sheet 179248



Part No: RB T101576-P

Job Qty: 1 ea

Part Name: Balance Set



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/15/18

Job Tracking No:

Due Date: 8/15/18 13

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB T101576 Rev.5 IPP Rev. A 18.06.08 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	8/10/18	8/10/18	0.00	0.00	Purchasing		SEP 20 2018
110	Packaging	1 pcs	8/10/18	8/10/18	0.00	0.00	Packaging2		SEP 20 2018
120	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC6		36
130	Packaging	1 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3		SEP 25 2018
140	QC21-FG	1 Ea	8/10/18	8/10/18	0.00	0.00	QC21		SEP 25 2018

Part Op 100 - Issue P/O: 040210 MANUFACTURE RB T101576 AS PER DWG Supplier: METEC -Certificate of conformity is
Descriptions: required

JUNE 15, 2018 x 1 *RL*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T101576P	Balance Set	1 (1 ea)	100-Purchasing	5112119

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T101576P	1	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/15/18 8:29 AM dart.Lussier.Patrick

Container No: S112123



Part: RB T101576

Job No: 179248

Serial No/Batch: S112123

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 09/20/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040210**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040210
PO Date: 6/15/18
Due Date: 8/17/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	8/17/18	1 pcs	0 pcs	1 pcs	\$6,548.85/pcs	\$6,548.85
Line Item Note: W/O 179113 FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.													
2		RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	8/17/18	1 pcs	0 pcs	1 pcs	\$6,548.85/pcs	\$6,548.85
Line Item Note: W/O 179246 DO NOT SHIP, PLEASE KEEP AT METEC FOR STOCK FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.													
3		RB T101576P			Balance Set	Firmed	-	8/17/18	1 Ea	0 Ea	1 Ea	\$2,440.20/Ea	\$2,440.20
Line Item Note: W/O 179025 DO NOT SHIP, PLEASE KEEP AT METEC FOR STOCK													
4		RB T101576P			Balance Set	Firmed	-	8/17/18	1 Ea	0 Ea	1 Ea	\$2,440.20/Ea	\$2,440.20
Line Item Note: W/O 179248 DO NOT SHIP, PLEASE KEEP AT METEC FOR STOCK													
Grand Total:												\$17,978.10	

Order Notes

Order Notes**Procurement Quality Clauses****A005 RIGHT OF ENTRY****A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)****A012 CHEMICAL AND PHYSICAL TEST REPORTS****A016 PERSONNEL QUALIFICATION****A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)****A026 CERTIFICATION OF MATERIAL CONFORMANCE****A041 QUALITY MANAGEMENT SYSTEM****A042 DART NOTIFICATION BY SUPPLIER****A043 RETENTION OF QUALITY DOCUMENT****A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM****A049 SUPPLIER AWARENESS**

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/17/18 1:20 PM dart.lavoie.chantal



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24055
Shipment Date: 20-Sep-2018
Ship Via: YOUR TRUCK
Order Number: PO040210 ✓
Order Date: 08/16/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO040210
Terms: ?

Quantity							Revision	Job Number
Item	Open	Shipped	B/O	Canceled	Unit	Description		
1	1	1 ✓	0	0	EA	DART-RB-T101576P Balance Set, drawing # RB T101576 Rev.5		PO040210-01

DAS
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The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1	RB-T101576P	Balance Set	5	40210

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

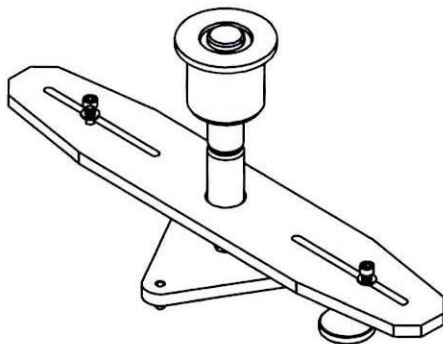
METEC Metal Technology Inc.


Joey Agostinucci

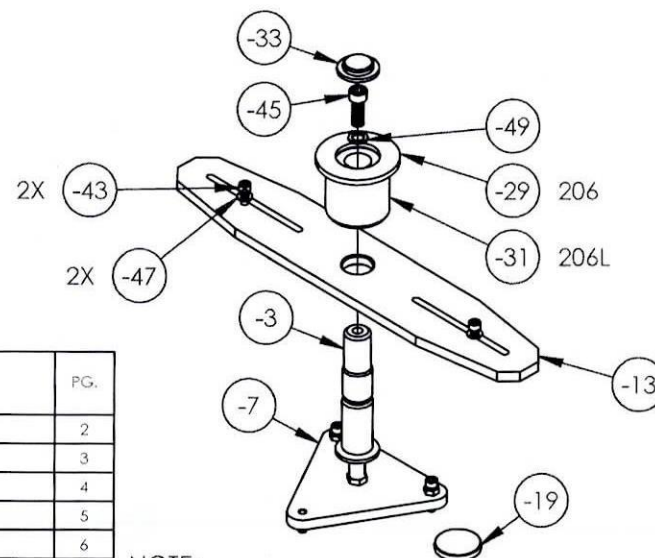
Vankleek Hill, September 20, 2018

DAS
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9-89

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDRAWN IN SOLIDWORKS PER UPDATED DWGS	1/18/2012	JAG	
2		CH'D -33 & -41 BOM B/O INFO. CH'D -11 ANGLE CALL OUT FROM 2X 60°. -29 ADDED DETAIL A & ENGRAVE "-29". DELETED R.05 & Ø1.537 FEATURES. CH'D DIAMETER FROM Ø1.435-1.437 TO Ø1.449-1.454. -31 ADDED DETAIL B & ENGRAVE "-31". DELETED R.05 & Ø1.537 FEATURES. CH'D DIAMETER FROM Ø1.435-1.437 TO Ø1.449-1.454 PER S.E.	3/16/2012	RJC	SE
3		-5 CH'D MATERIAL WAS 440C IS 303. -9 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø1/2 X 4-7/8 IS Ø5/8 X 4-7/8. -11 CH'D MATERIAL WAS 440C IS 303. -13 CH'D MATERIAL WAS 2024 IS 6061. -21 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø7/8 X 1/2 IS Ø3/4 X 1/2. -29 & -31 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø2-3/4 X 2-5/16 IS Ø3 X 2-5/16.	6/25/2013	BIM	EB
4		-5 REMOVED HEAT TREAT REQUIREMENT. ADDED .13 X .45° DIM. -29 & -31 CH'D DIM. FROM .030 TO .03	11/26/2013	JAG	GE
4A		CH'D TITLE BLOCK TOLERANCE WAS .XXX ±.005 IS ±.010. WAS .XX ±.01 IS ±.03 PER BELL DWG. -9 CH'D MATERIAL WAS Ø5/8 303 IS Ø1/2 303 G&P. DELETED HEAT TREAT WAS RC 58 MIN.	3/26/2014	RJC	GE
5	15-0067	-9 CH'D MATERIAL WAS 303 G&P IS 440C. ADDED HEAT TREAT RC 54-60. -11 DELETED HEAT TREAT 9-25 HRC. -13 ADDED ENGRAVE T/N, S/N. MADE IN USA NOTE. -21 CH'D HEAT TREAT WAS FOR MILITARY HEAT TREAT RC 40-44. IS RC 54-60. -29 & -31 DELETED HEAT TREAT 35-40 HRC.	4/15/2015	RJC	JAG



NOTE:
FOR 206 USE -29 IN ASSEMBLY
FOR 206L USE -31 IN ASSEMBLY

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-3	1	MANDREL ASSY			2
	1		-5		MANDREL	303		3
X			-7	1	STAND ASSY			4
1			-9		STAND	440C		5
1			-11		PLATE	303		6
			-13	1	BASE	6061		7
			-19	1	PLATE	17-4 PH		8
	1		-21		PLUG	440C		9
			-29	1	PLUG (USE ON 206)	303		10
			-31	1	PLUG (USE ON 206L)	303		11
		B/O	-33	1	BULL'S EYE LEVEL	BRASS	GEIER & BLUHN #2-14000 (MSC #0555933)	1
2		B/O	-37		HEX NUT	316	1/4-28 UNF (MCMaster-CARR #90257A033)	4
1		B/O	-39		HEX NUT	316	3/8-24 UNF (MCMaster-CARR #94805A217)	4
1		B/O	-41		DOWEL PIN	316	Ø1/4 X 3/4 (MCMaster-CARR #97395A485)	4
2		B/O	-43	2	SOCKET HEAD CAP SCREW	316	1/4-28 UNF (MCMaster-CARR #92185A564)	4
		B/O	-45	1	SOCKET HEAD CAP SCREW	316	3/8-24 UNF (MCMaster-CARR #92185A673)	1
		B/O	-47	2	FLAT WASHER	300 S.S.	I.D. 1/4 (MCMaster-CARR #98017A660)	1
		B/O	-49	1	WASHER	300 S.S.	I.D. 3/8 (MCMaster-CARR #98017A200)	1
	1	B/O	-51		BALL	E52100 STEEL	Ø3/4 GRADE 25 (MCMaster-CARR #9528K29)	2
	1	B/O	-55		O-RING	VITON	Ø3/32 X I.D. 9/16 X O.D. 3/4 (MCMaster-CARR #2857T1128)	2
ASSY -7	ASSY -3							

DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T101576	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: CLOUGH
.XXX ± .010 FRACTIONS ± 1/8	APPROVED <i>D. Weid</i>
.XX ± .03 ANGLES ± 5°	HEAT TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:5	BELL 206 & 206L
DATE 1/9/2012	SHEET 1 OF 11